

Work Order ID 92118

Tuesday, October 23, 2012 4:09:46 PM

92118

Page 1

Item ID: PB67-43001-15

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 10/23/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/2/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: ML5 Date: 12-10-25 Tooling: _____

Date: _____

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Run Start ***NR1***Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| | |
|--------------|--------------|
| Draw Nbr | Revision Nbr |
| B67-43001-15 | Rev C |

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1- make a 0.090" chamfer in the 1.00" hole before welding

2- assemble parts and weld as per dwg

3- grind weld flush in area of PB67-43001-249 only

4- install helicol insert as per dwg

(4x) CC 12-12-5

110

QC9- Inspect visual per QSI004- Fusion Welds / 0.00

110

QC

Memo

0.00

Quality Control

(4) 12-12-07

Work Order ID 92118

Tuesday, October 23, 2012 4:09:46 PM

92118

Page 2

Item ID: PB67-43001-15 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Fwf Adjustable Blade Support Assembly
 Start Date: 10/23/2012 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 11/2/2012 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| | | | | | | | | | |
|-----------------|---|------|--|--|--|--|--|--|--|
| 120 | QC5- Inspect part completeness to step on W/O ✓ | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

| | | | | | | | | | |
|----------------|---|------|--|--|--|--|--|--|--|
| 150 | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | | | | | | | | | |

| | | | | | | | | | |
|----------------|---|------|--|--|--|--|--|--|--|
| 160 | Green Sandtex(Ref:4.3.5.8) per QSI005 4.3 | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| Powdercoat | Memo | 0.00 | | | | | | | |
| Powder Coating | | | | | | | | | |

8:30 - MASK TUBE FROM BASE TO GUSSET START TIME:
 OVEN TEMPERATURE: 320°F FINISH
 TIME: 9:20

M18144

9:20

4 12-12-07



4 12/12/11

4X ✓ 12/12/11

28

Work Order ID 92118

Tuesday, October 23, 2012 4:09:46 PM

92118

Page 3

Item ID: PB67-43001-15

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 10/23/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/2/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

4 ✓ f M alul 11

180

Small Fab

0.00

180

Small Fab

Memo

0.00

Small Fab

1- match drill cover to existing holes in support2- assemble as per dwg

4 8 12-12-11

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

DAS
15
2-89
101212

4

Work Order ID 92118

Tuesday, October 23, 2012 4:09:46 PM

92118

Page 4

Item ID: PB67-43001-15

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 10/23/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/2/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

Identify as per dwg & Stock Location: *W4*

0.00

200

Packaging

Memo

0.00

Packaging

*4**Q**12.12.12*

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

*12/12/13**12-12-12*

Picklist Print

Tuesday, October 23, 2012 4:09:45 PM

Page 1

Work Order ID: 92118

Parent Item: PB67-43001-15

Parent Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 10/23/2012

Required Date: 11/2/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec
dwg EC verified by:DD

IPP Rev B 10.09.28 per rev C

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| PB67-43001-71 | | Manufactured | No | | | | Each | 1.0000 | | 4 | | CC 12.12.5 | |
| 20° Blade Support Assembly | | | | | | | | | | | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST437A | | 1 | | B92085 | | | (4X) | | |
| | | | | 41512 | | 1 | | | | | | | |
| PB67-43001-249 | | Manufactured | No | | | 100 | Each | 3.0000 | 1 | 4 | | CC 12-12-5 | |
| Inner Tube Bushing | | | | | | | | | | | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST438 | | 3 | | B90927 | | | (4X) | | |
| | | | | 52480 | | 3 | | | | | | | |
| PB67-43001-253 | | Manufactured | No | | | 100 | Each | 7.0000 | 1 | 4 | | CC 12-12-5 | |
| Gusset | | | | | | | | | | | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | WA | | 7 | | B90928 | | | (4X) | | |
| | | | | 85185 | | 7 | | | | | | | |
| PB67-43001-254 | | Manufactured | No | | | 100 | Each | 16.0000 | 1 | 4 | | CC 12-12-5 | |
| Gusset | | | | | | | | | | | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST438 | | 16 | | B | | | (4X) | | |
| | | | | 52481 | | 16 | | | | | | | |
| PB67-43001-257 | | Manufactured | No | | | 100 | Each | 0.0000 | 1 | 4 | | CC 12-12-5 | |
| Inner Tube | | | | | | | | | | | | | |
| MS124780 | | Purchased | No | | | 180 | Each | 82.0000 | 1 | 4 | | 12.12.06 | |
| HELICAL INSERT | | | | | | | | | | | (4X) | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST333 | | 82 | | | | | | | |
| | | | | 111064 | | 82 | | | | | 4 | | |

Picklist Print

Tuesday, October 23, 2012 4:09:45 PM

Page 2

Work Order ID: 92118

Parent Item: PB67-43001-15

Start Date: 10/23/2012

Required Date: 11/2/2012

Parent Item Name: Fwf Adjustable Blade Support Assembly

Start Qty: 4.00

Required Qty: 4.00

MS27039-1-10

Screw

Purchased No

180 Each 416.0000 8

32 *m/d 3522 SP*

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| 308 | 8 | |
| 122441 | 8 | |
| GA | 100 | |
| 120449 | 100 | |
| ST291 | 5 | |
| 120120 | 5 | |
| ST305 | 300 | |
| 122815 | 300 | |
| ST308 | 3 | |
| 122027 | 3 | |

NAS1149D0316J

Washer

Purchased No

180 Each 400.0000 8

32 *SP*

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| ST298 | 400 | |
| 122151 | 400 | |

m/d 23482 32x

NAS1149D0363J

Washer

Purchased No

180 Each 4,785.0000 8

32 *SP 12-12-7*

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| ST294 | 1854 | |
| 123248 | 1254 | |
| 123355 | 600 | |
| ST297 | 2820 | |
| 122378 | 2820 | |
| ST298 | 111 | |
| 117601 | 61 | |
| 119537 | 33 | |
| 120308 | 17 | |

32x

Picklist Print

Tuesday, October 23, 2012 4:09:45 PM

Page 3

Work Order ID: 92118

Parent Item: PB67-43001-15

Parent Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 10/23/2012

Required Date: 11/2/2012

Start Qty: 4.00

Required Qty: 4.00

PB67-43001-73

Manufactured No

180 Each 5.0000

1

4

SP-

20-Degree Cover Plate

Location

Loc Qty

Loc Code

ST437A

5

53305

5

4X

Manufactured No

180 Each 5.0000

1

SP12-12-7.

PB67-43001-83

PB67-43001-83

Location

Loc Qty

Loc Code

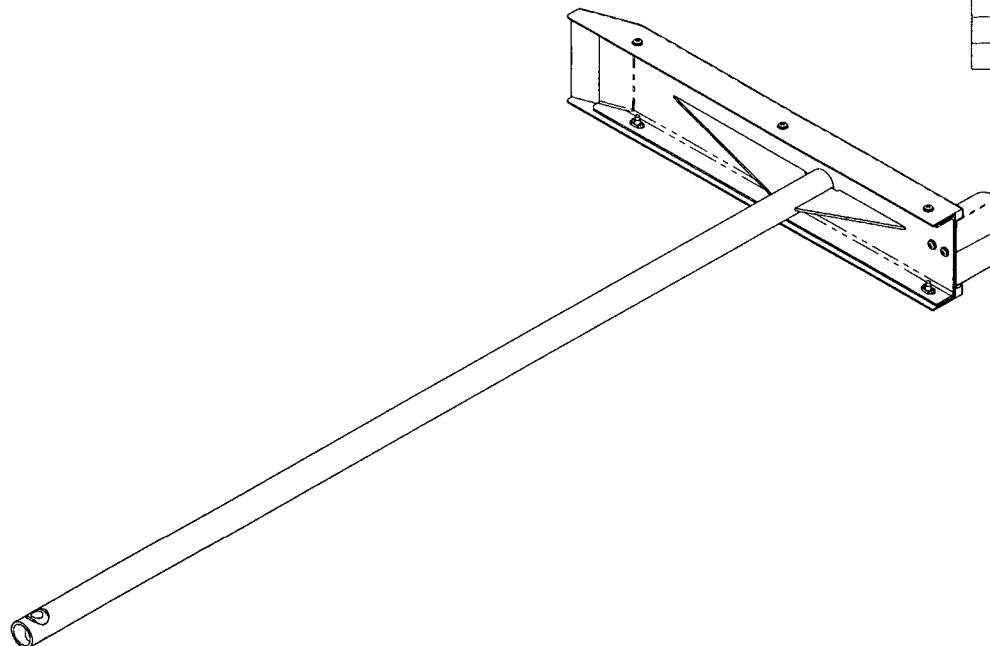
ST444

5

53240

5

4X



B67-43001-15 FWD ADJUSTABLE BLADE SUPPORT ASSY

| ITEM | QTY -15 | P/N | DESCRIPTION |
|------|------------|---------------|---------------------------------------|
| 1 | X | B67-43001-15 | FWD ADJUSTABLE BLADE SUPPORT ASSEMBLY |
| 2 | 1 | B67-43001-15W | FWD ADJUSTABLE BLADE SUPPORT WELDMENT |
| 3 | 1 | B67-43001-73 | 20" COVER PLATE |
| 4 | 1 | B67-43001-83 | SHORT D-PAD ASSY |
| 5 | 8 | MS27039-1-10 | SCREW |
| 6 | 8 | NAS1149D0316J | WASHER |
| 7 | 6 | NAS1149D0363J | WASHER |

COPY
 TO
 DRAWING
 CONTROLLED COPY
 TO MINIMUM
 NOTICE
 ORDER
 92118 ML5
 12-10-25

RELEASED
 R 2010-09-16
 MD

| | | | | | |
|------------|----------|--|--------------|------|----------|
| C | | REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 7 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011. | | MB | 10.04.28 |
| REV. | | DESCRIPTION | BY | DATE | |
| DESIGN | RW | DART AEROSPACE LTD | | | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | | | |
| CHECKED | | DRAWING NO. | REV. C | | |
| MFG. APPR. | | B67-43001-15 | SHEET 1 OF 2 | | |
| APPROVED | | TITLE | SCALE | | |
| DE APPR. | N/A | FWD ADJUSTABLE BLADE SUPPORT ASSY | NTS | | |
| DATE | 10.04.28 | COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | | | |

8 7 6 5 4 3 2 1

92118

B67-43001-15W FWD ADJUSTABLE
BLADE SUPPORT WELDMENT
REF

NAS1149D0363J
WASHER

MS27039-1-10 SCREW [8]
NAS1149JD0316J WASHER

B67-43001-73
20" COVER PLATE
REF

SECTION A-A B7-2
SCALE 4X, 6 PL

B67-43001-73
20" COVER PLATE

B67-43001-15W FWD ADJUSTABLE
BLADE SUPPORT WELDMENT

MS27039-1-10 SCREW
NAS1149JD0316J WASHER
2 PL [8]

B67-43001-15 FWD ADJUSTABLE BLADE SUPPORT ASSY

B67-43001-83
D-PAD ASSEMBLY, SHORT

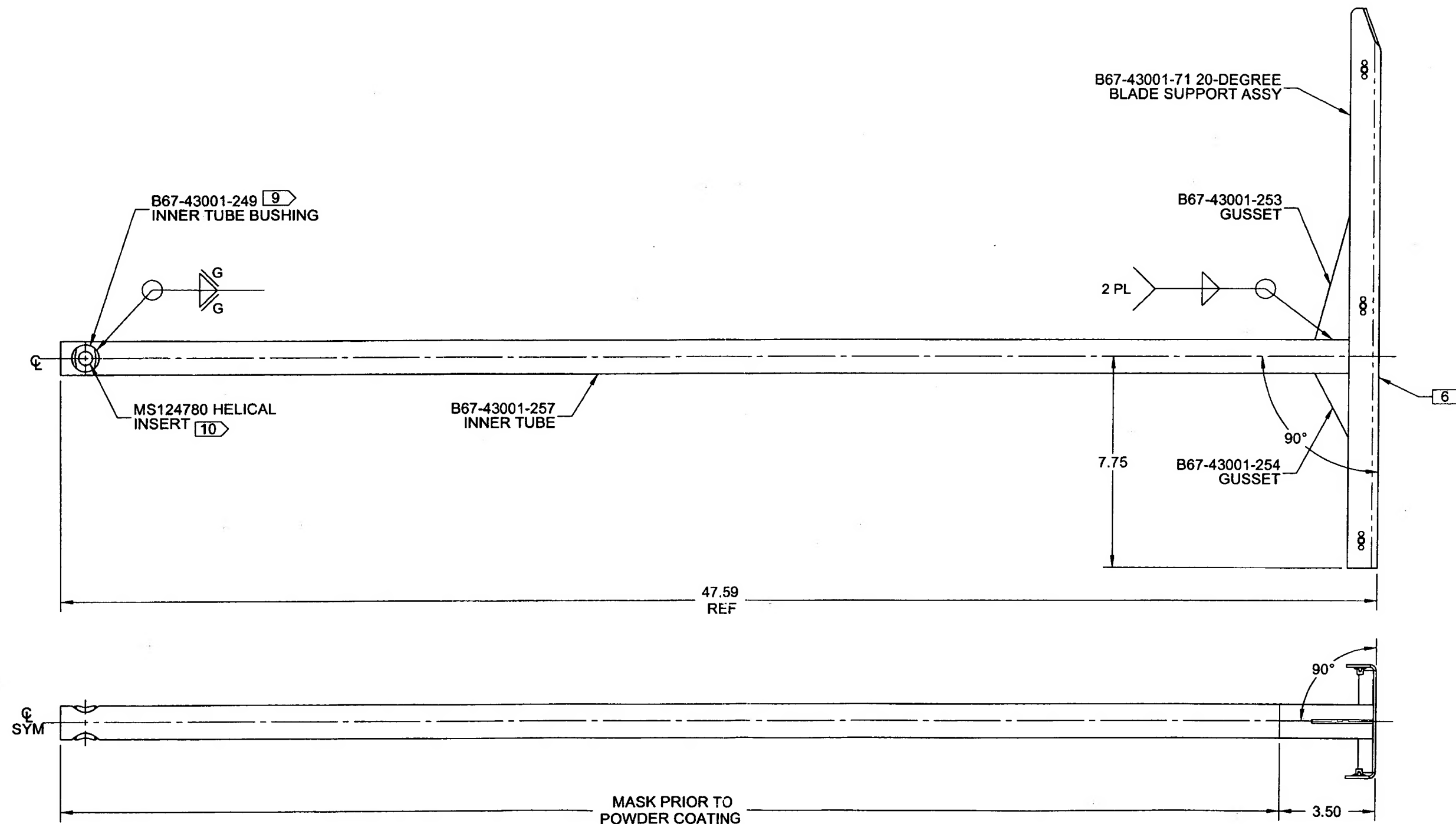
RELEASED
2010-09-16

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 8.70 lbs
- 8) LOCATE PARTS AS SHOWN AND TRANSFER DRILL $\phi 0.250$ TO $\phi 0.257$ HOLES FROM EXISTING HOLE PATTERNS ON B67-43001-15W AND B67-43001-83 TO B67-43001-73

| | | | |
|------------|----------|--|--------------|
| DESIGN | RW | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. C |
| MFG. APPR. | | B67-43001-15 | SHEET 2 OF 2 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | N/A | FWD ADJUSTABLE BLADE SUPPORT ASSY | NTS |
| DATE | 10.04.28 | <small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

8 7 6 5 4 3 2 1



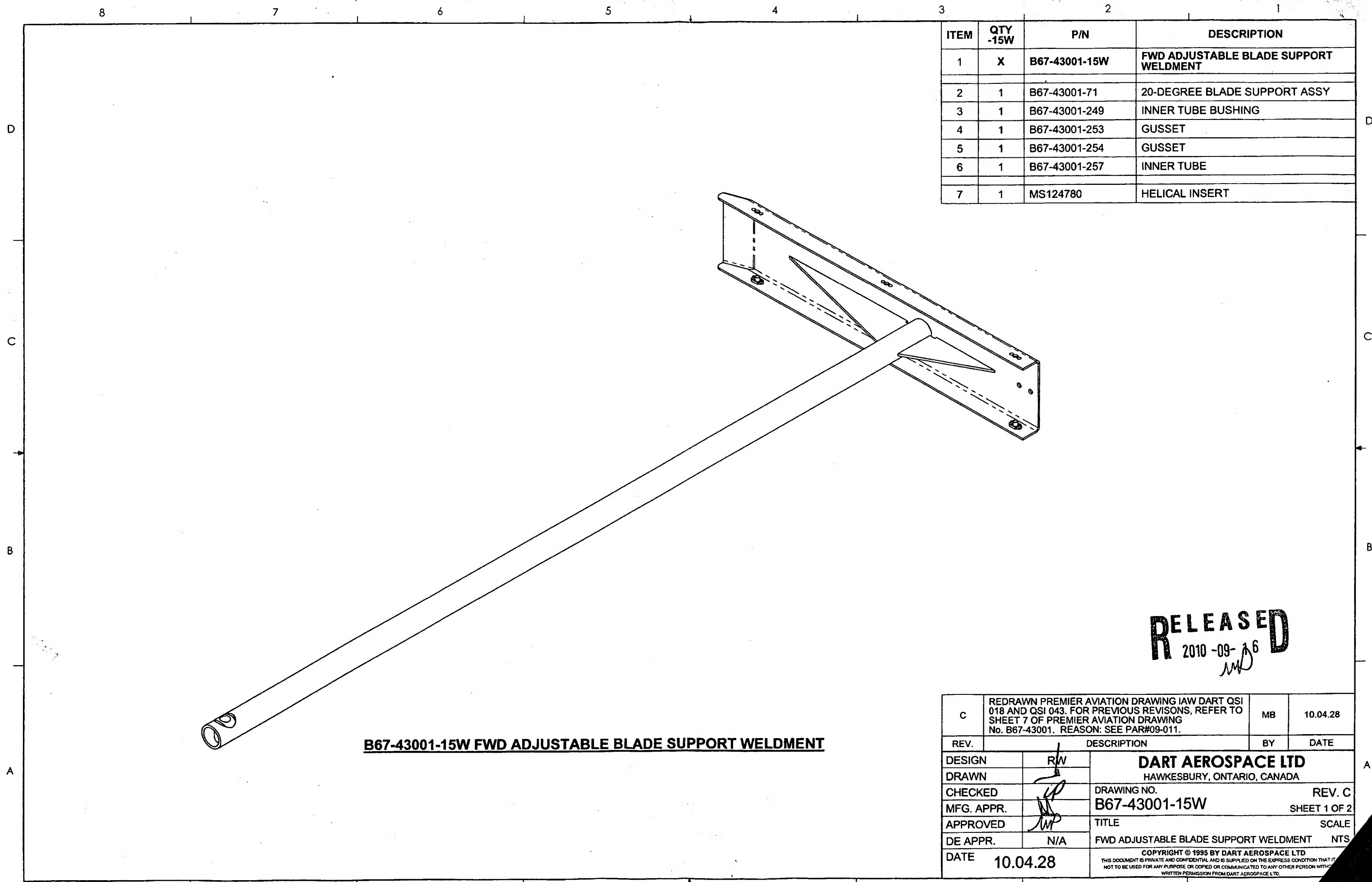
B67-43001-15W FWD ADJUSTABLE BLADE SUPPORT WELDMENT

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT "GREEN SANDTEX" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-15W" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 3.35 lbs
- 8) WELDING: PER QSI 004
- 9) GRIND B67-43001-249 BUSHING AND WELD TO CONTOUR OF TUBE IN ACCORDANCE WITH NOTE 8
- 10) INSTALL HELICAL INSERT PER MS33537

| | | | |
|------------|----------|---|--------------|
| DESIGN | RW | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. C |
| MFG. APPR. | | B67-43001-15W | SHEET 2 OF 2 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | N/A | FWD ADJUSTABLE BLADE SUPPORT WELDMENT | NTS |
| DATE | 10.04.28 | <small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

RELEASED
2010-09-16



| ITEM | QTY -15W | P/N | DESCRIPTION |
|------|-------------|---------------|---------------------------------------|
| 1 | X | B67-43001-15W | FWD ADJUSTABLE BLADE SUPPORT WELDMENT |
| 2 | 1 | B67-43001-71 | 20-DEGREE BLADE SUPPORT ASSY |
| 3 | 1 | B67-43001-249 | INNER TUBE BUSHING |
| 4 | 1 | B67-43001-253 | GUSSET |
| 5 | 1 | B67-43001-254 | GUSSET |
| 6 | 1 | B67-43001-257 | INNER TUBE |
| 7 | 1 | MS124780 | HELICAL INSERT |

B67-43001-15W FWD ADJUSTABLE BLADE SUPPORT WELDMENT

RELEASED
2010-09-16
MD

| | | | |
|------------|--|---|----------|
| C | REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 7 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011. | MB | 10.04.28 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | R/W | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | <i>[Signature]</i> | DRAWING NO. B67-43001-15W REV. C SHEET 1 OF 2 | |
| CHECKED | <i>[Signature]</i> | TITLE FWD ADJUSTABLE BLADE SUPPORT WELDMENT SCALE NTS | |
| MFG. APPR. | <i>[Signature]</i> | DATE 10.04.28 | |
| DE APPR. | N/A | COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

